

Work Order ID 63769

Friday, November 12, 2010 1:20:42 PM



RH.

Page 1

Item ID: D4278-041

Accept



Setup Start



Revision ID: PRELIM

Item Name: Upper Rib Assembly-Hoop

Stop



Start Date: 11/15/2010 Start Qty: 1.00

Required Date: 11/16/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan:

MF

Date: 10-11-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4278

PA1

100

Weld per dwg A/R S.S. rod Batch: 110585 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT

2- Weld bushing in rib and grind weld flush as per dwg

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CP 10.11.25

BE
12 10.11.25

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

- inspect to PA1

Dwg only

5/10/12/25

@

Work Order ID 63769

Friday, November 12, 2010 1:20:42 PM



Page 2

Item ID:	D4278-041	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Upper Rib Assembly-Hoop					
Start Date:	11/15/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	11/16/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: <i>B/C</i> Memo ***STOCK IN BASKET CELL***	0.00 0.00		<i>Op 10.11.25</i>		<i>(1x)</i>			
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00		<i>A. test. kept</i>		<i>Rec. A 10.11.30</i>			

POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

MF 10-11-25

Picklist Print

Page 1

Friday, November 12, 2010 1:20:41 PM

Work Order ID: 63769

Parent Item: D4278-041

Parent Item Name: Upper Rib Assembly-Hoop





Start Date: 11/15/2010


Required Date: 11/16/2010


Start Qty: 1.00


Required Qty: 1.00


Comments: IPP Rev:A 10.11.12 new issue DD verf:EC

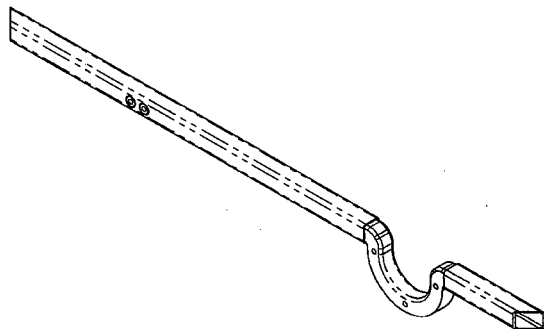
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4021-7  Hoop		Manufactured	No			100	Each	7.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				7					
					58039			1					
					63115			6					
✓ D4021-9  Bushing		Manufactured	No			100	Each	22.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				22					
					56094			2					
					60184			4					
					60803			16					
* D4034-1  Rib		Manufactured	No			100	Each	0.0000	1	1			
✓ D4034-3  Rib		Manufactured	No			100	Each	0.0000	1	1			

 10.11.25

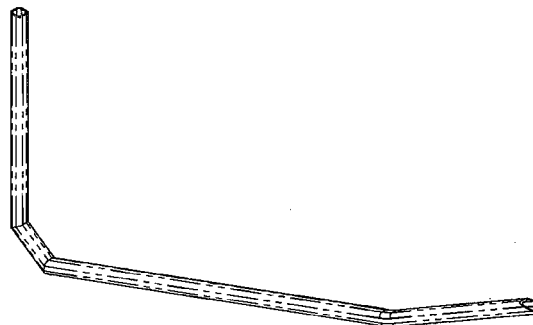
 10.11.25

 10.11.25

 10.11.25



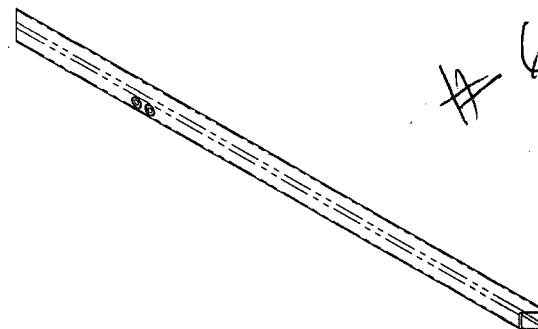
D4278-041 UPPER RIB ASSY-HOOP



D4278-043 RIB ASSY. AFT CHAM



D4278-045 RIB ASSY. FWD CHAM

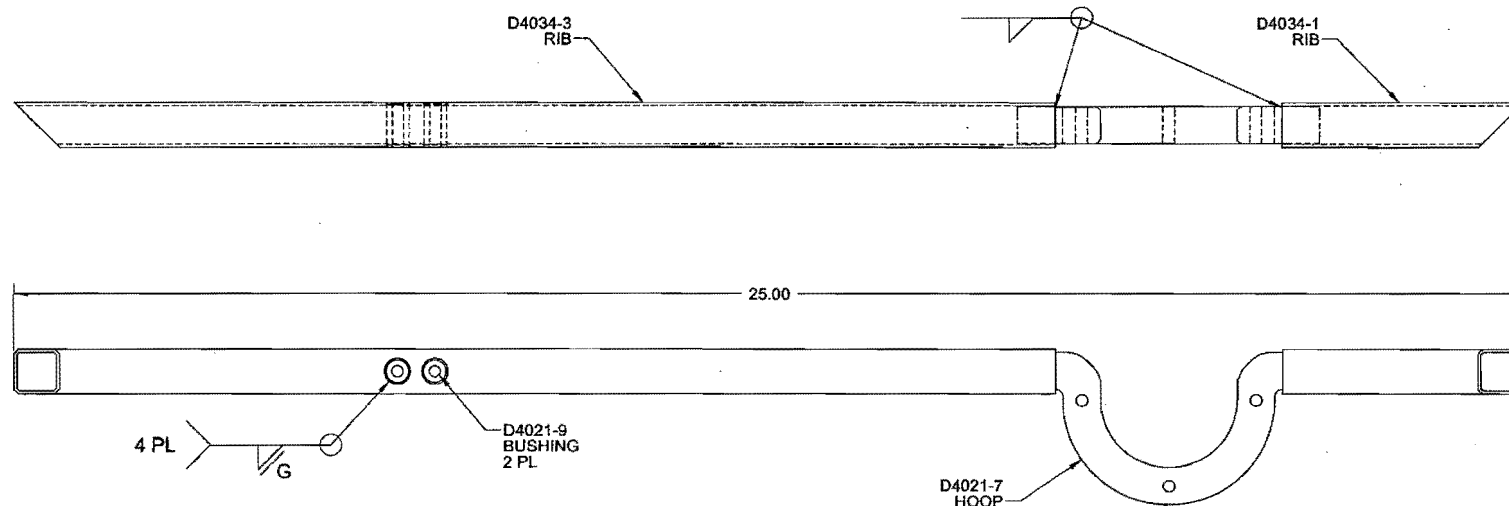


D4278-047 UPPER RIB ASSY-STRAIGHT

PRELIMINARY ISSUE
Nov 11, 2010

PA1	PRELIMINARY	JPH	10.11.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. PA1
MFG. APPR.	JPH	D4278	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSEMBLY	NTS
DATE	10.11.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	2	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB






D4278-041 UPPER RIB ASSY-HOOP

PRELIMINARY ISSUE

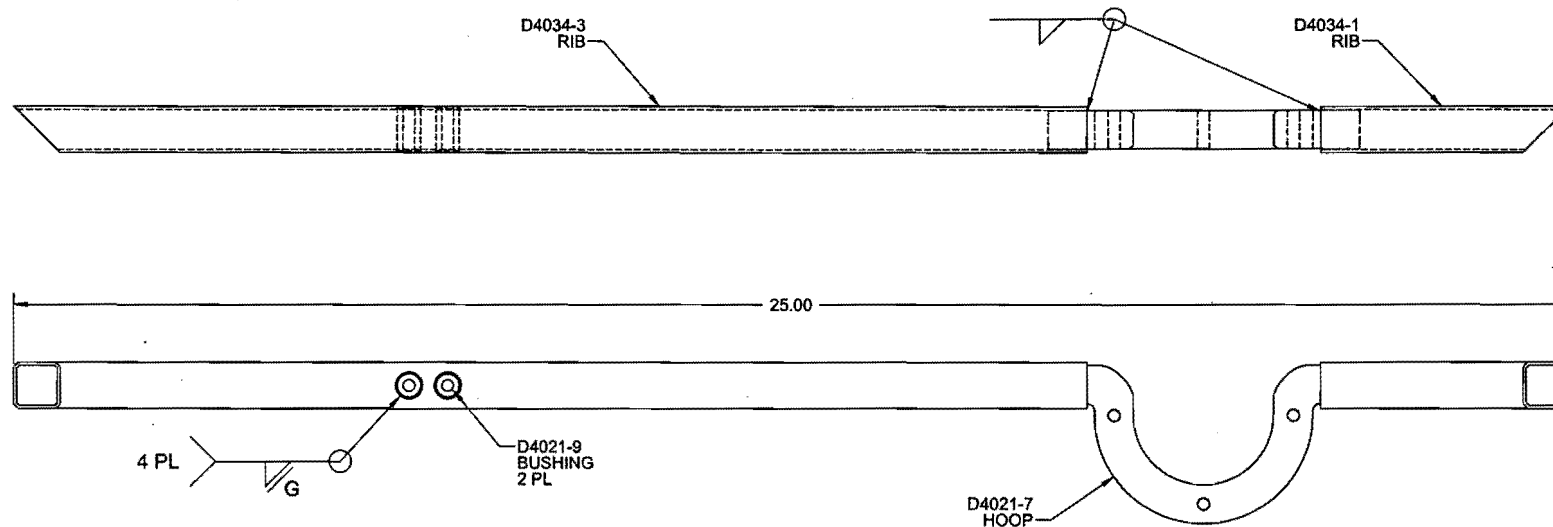
Nov 11, 2010 *fl*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.59 lbs
- 8) WELD PER DART QSI 004

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA
MFG. APPR.		D4278	SHEET 2 OF
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	10.11.11	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	2	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



D4278-041 UPPER RIB ASSY-HOOP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.59 lbs
- 8) WELD PER DART QSI 004

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4278	SHEET 2 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSEMBLY	NTS
DATE	10.11.25	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	